

Work Order ID 61012



Page 1

August 4, 2010 8:56:34 AM

Item ID: D4150-3

Accept



Setup



Start

Revision ID:

Stop

Item Name: Arm Plate

Start Date: 8/04/10 Start Qty: 10.00



Cust Item ID:

Required Date: 8/11/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-8-04

Tooling:

Date:

Run

QC:

Date:

SPC (Y/N):

Date:

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D4150	B

100

0.00



Waterjet

Memo

0.00

10-8-5

FLOW CNC Waterjet

304 125

Cut as per dwg D4150
Prog Rev: B
Dwg Rev: B

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

10-8-5

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61012

August 4, 2010 8:56:34 AM



Page 2

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Date:

Tooling:

Date:

Run

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool

ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

S1088105

144

150



Packaging

Packaging

Identify as per dwg & Stock Location: 123

0.00

0.00

10/8/16 SP 140

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/09 JF

MF 10-8-06

W/O:		WORK ORDER CHANGES					
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Picklist Print

August 4, 2010 8:56:39 AM

Page 1
5**Work Order ID:** 61012**Parent Item:** D4150-3**Parent Item Name:** Arm Plate**Start Date:** 8/04/10**Required Date:** 8/11/10**Start Qty:** 10.00**Required Qty:** 10.00**Comments:** IPP Rev:A 10.06.24 new issue DD verf:EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased		No		100	sf	91.2982	0.0254	0.267368	36 8/10-8-5		

304/316 0.125 Sheet

Location	Loc Qty	Loc Code
MAT	91.2982	
114488	1.5259	
114799	89.7723	114488

(14)

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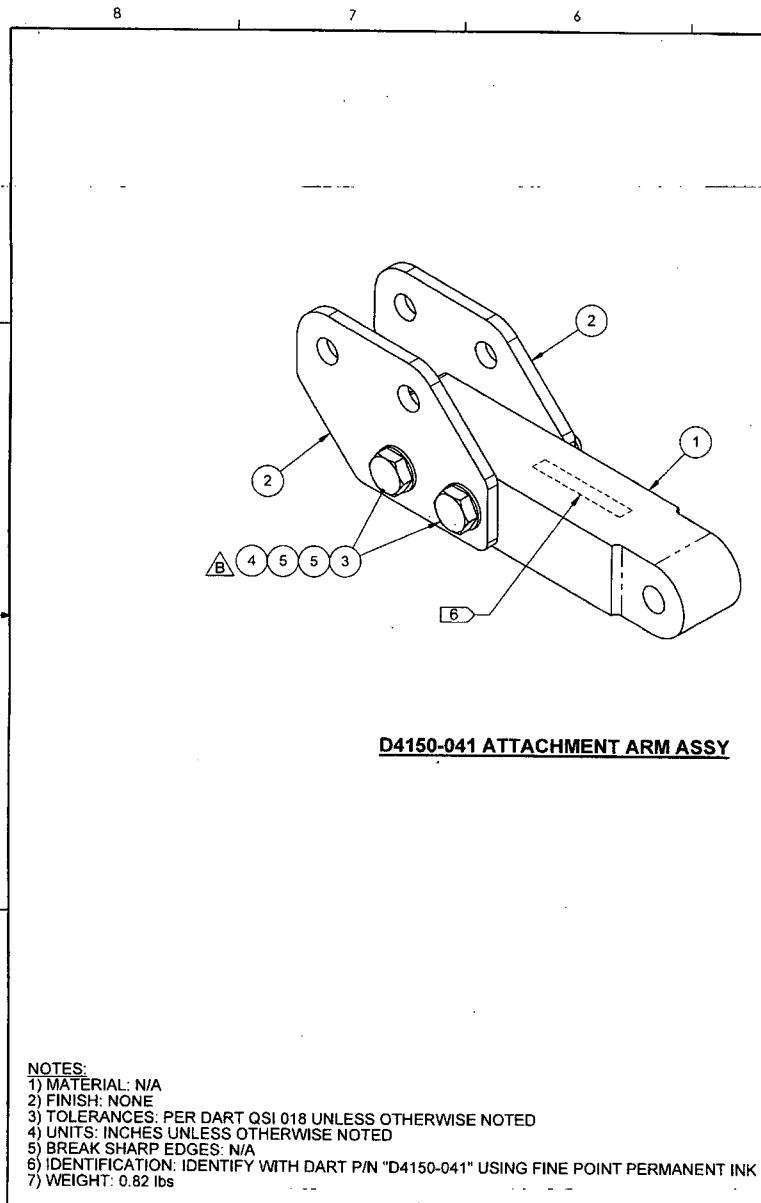
NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	61012
Description: ARM PLATE	Part Number:	D4150-3
Inspection Dwg: D4150-3 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	13	Audited by:	✓	Prototype Approval:	N/A
Date:	10-8-5	Date:	(10/28/05)	Date:	N/A



ITEM	QTY -041	P/N	DESCRIPTION
	X	D4150-041	ATTACHMENT ARM ASSY
1	1	D4150-1	ARM
2	2	D4150-3	ARM PLATE
3	1	AN3C13A	BOLT
4	1	MS21043-3	NUT
5	2	NAS1149C0332R	WASHER

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. *61012*
28/08/09

RELEASED
 2010-07-16
NP

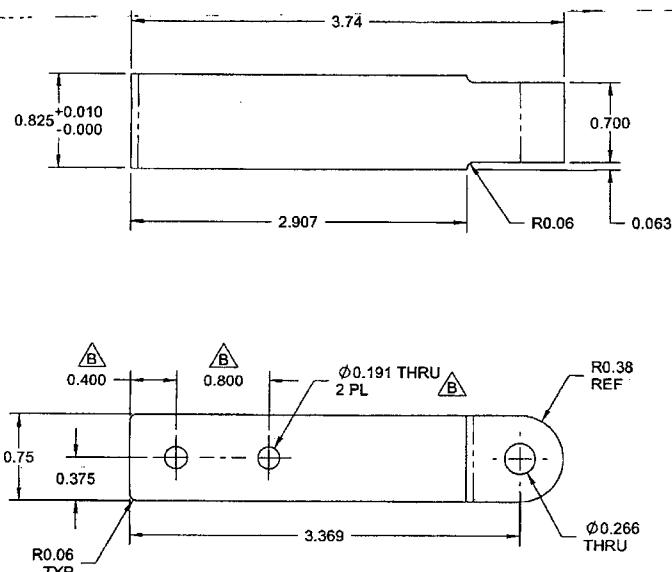
B	REPLACED QTY(3) MS20615-4M20 WITH QTY(2) EACH AN3C13A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZINC D3-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZINC D3-1); Ø0.191 2 PL REASON: SEE TR-D350-501-2 REV. B.	MB	10.07.08
A	NEWISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>1</i>	DART AEROSPACE LTD	
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>1</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>1</i>	D4150	SHEET 1 OF 3
APPROVED	<i>1</i>	TITLE	SCALE
DE APPR.	<i>1</i>	ATTACHMENT ARM ASSY	NTS
DATE	10.07.08	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE MADE OR PROVIDED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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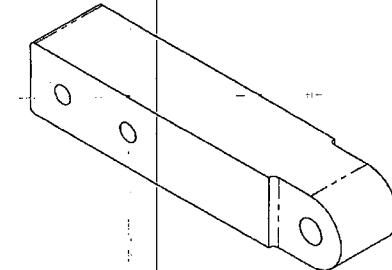
NOTE: Date & initial all entries



D4150-1 ARM

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.60 lbs



W061012

RELEASED
R 2010-07-16
MP

DESIGN	1	b	DART AEROSPACE LTD
DRAWN	1		HAWKESBURY, ONTARIO, CANADA
CHECKED	2		DRAWING NO.
MFG. APPR.	3		REV. B
APPROVED	4		D4150
DE APPR.	5		SHEET 2 OF 3
DATE	10.07.08		TITLE: ATTACHMENT ARM ASSY
			SCALE: NTS

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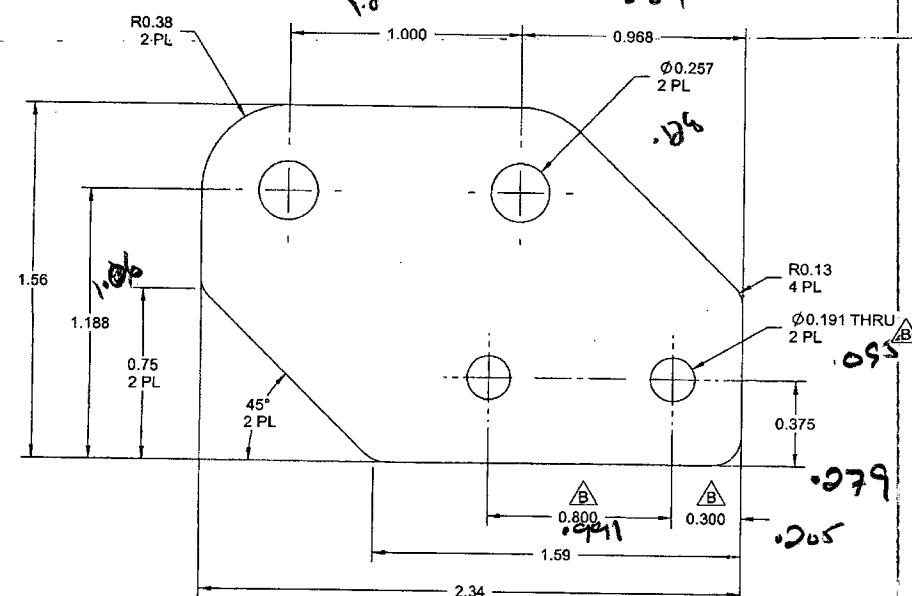
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NOTE: Date & initial all entries



D4150-3 ARM PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. D4150
MFG. APPR.	<i>[Signature]</i>	REV. B
APPROVED	<i>[Signature]</i>	SHEET 3 OF 3
DE APPR.	<i>[Signature]</i>	TITLE ATTACHMENT ARM ASSY
DATE	10.07.08	SCALE NTS

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2010-07-16
[Signature]

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